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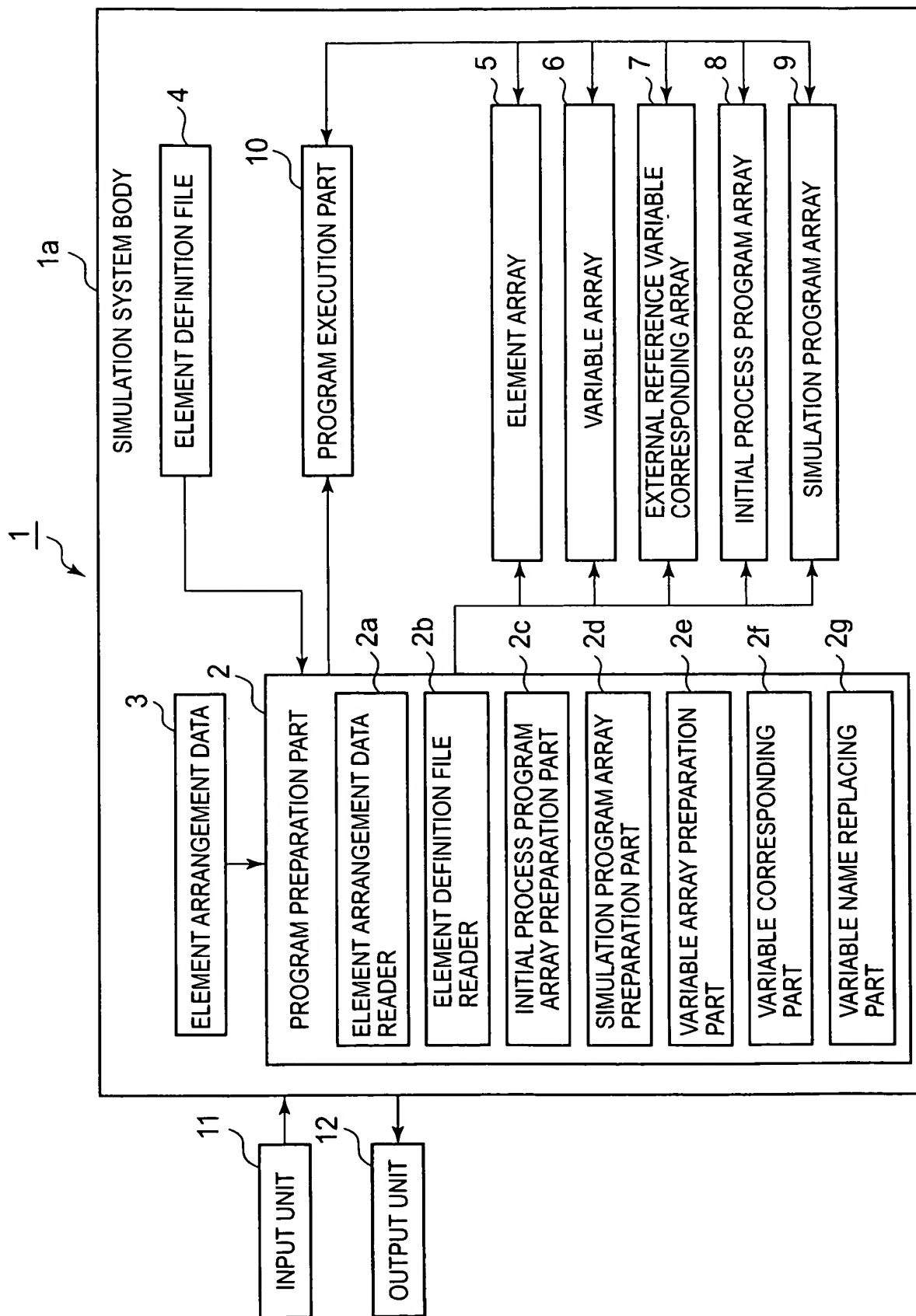


FIG. 1

[illegible]

FIG. 2

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4 (ELEMENT DEFINITION FILE)

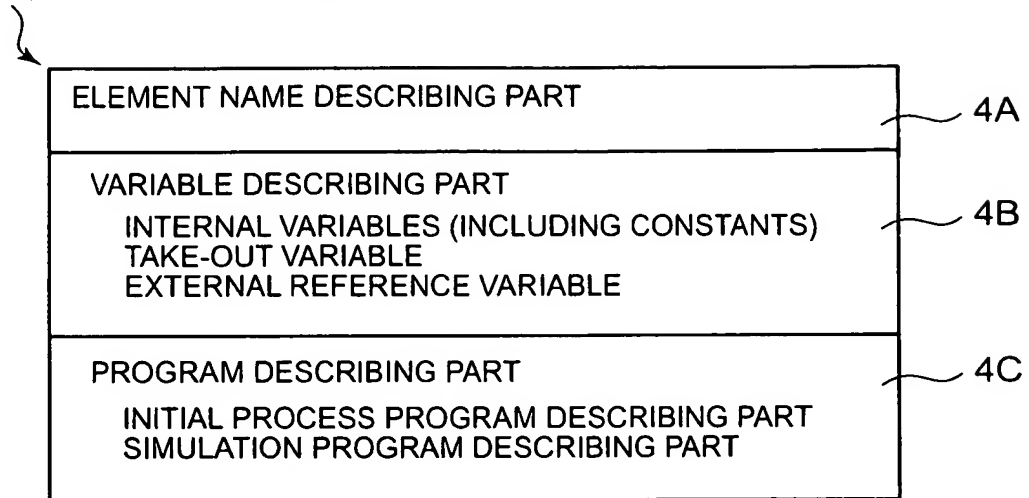


FIG. 3

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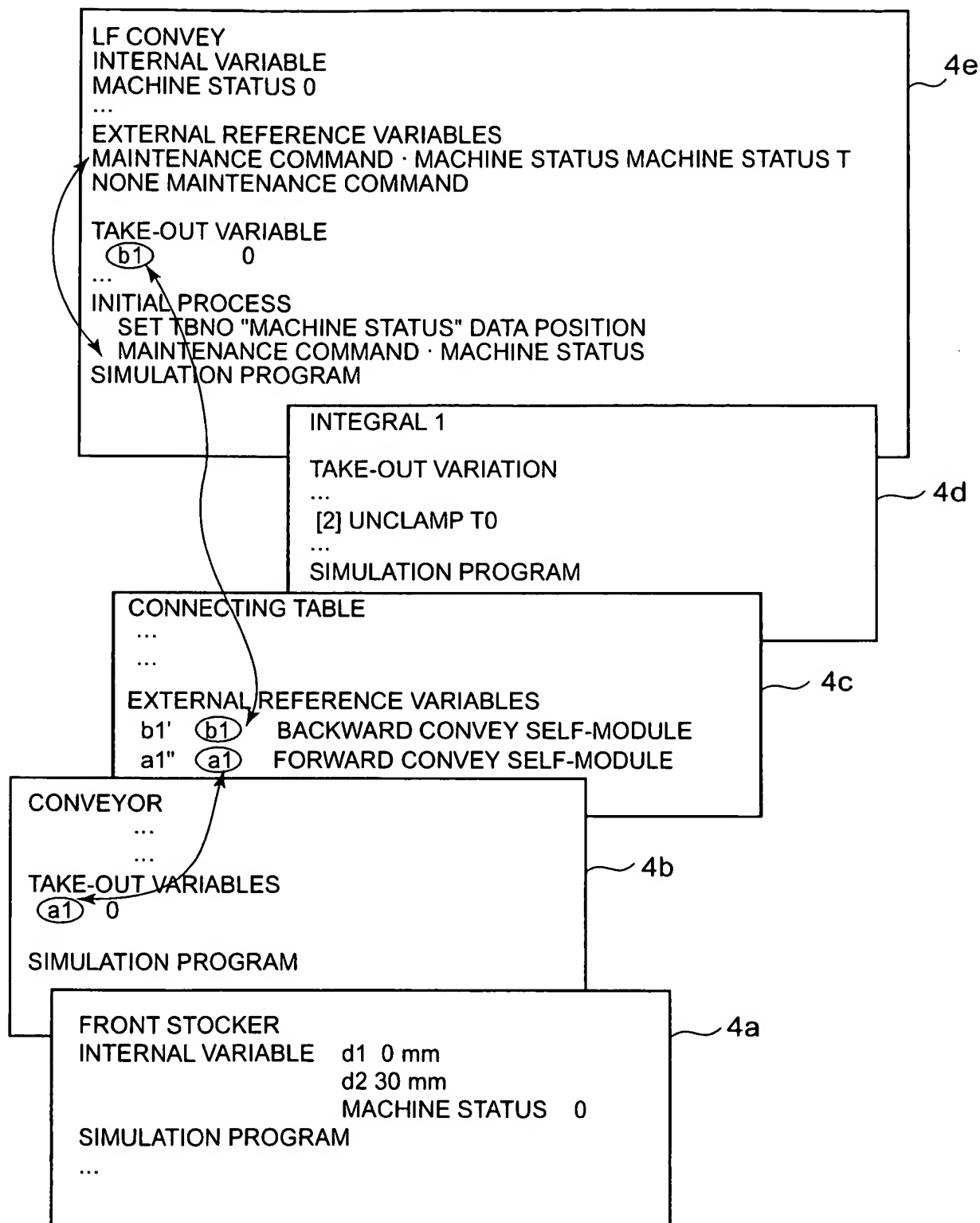


FIG. 4

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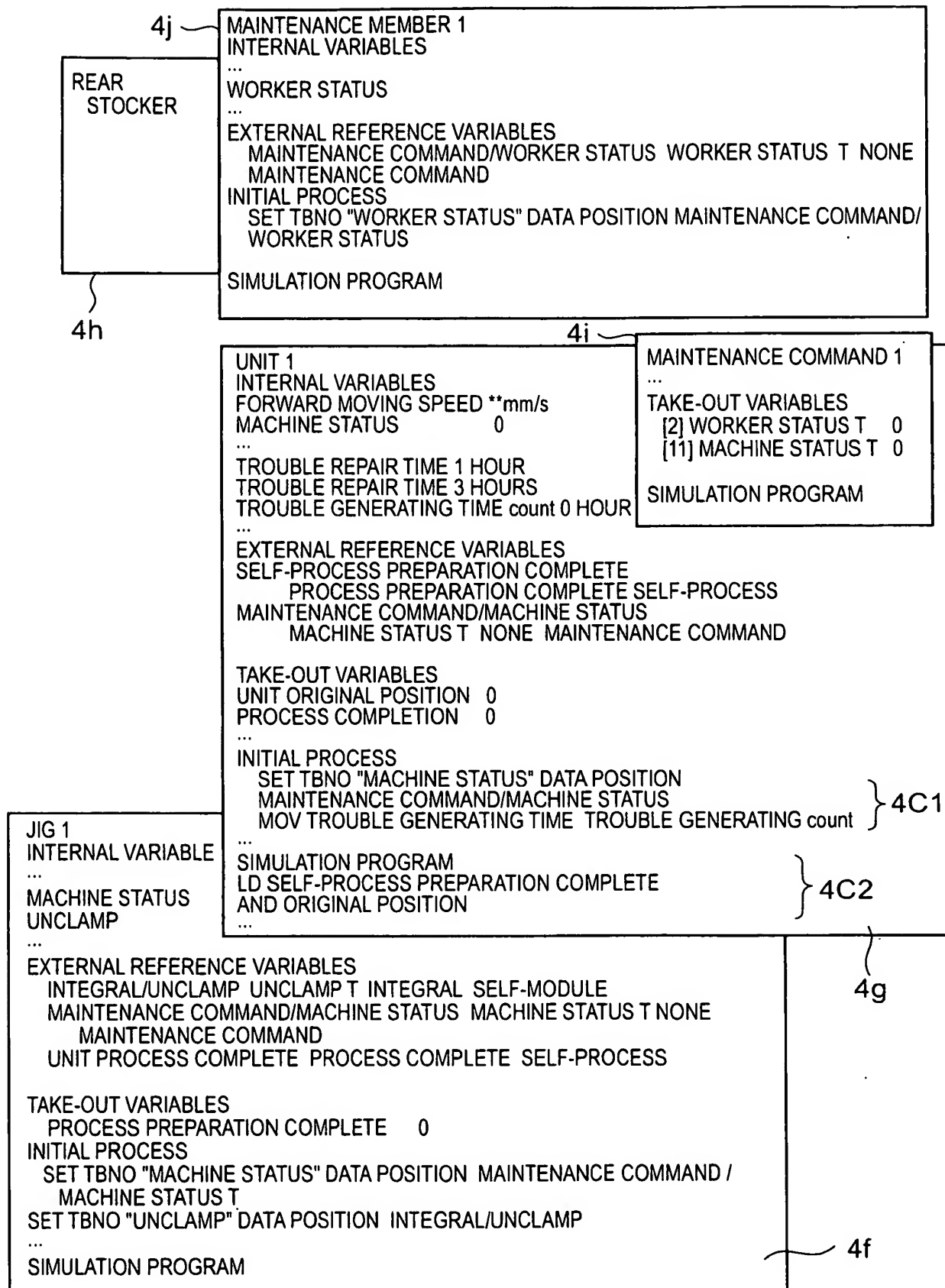
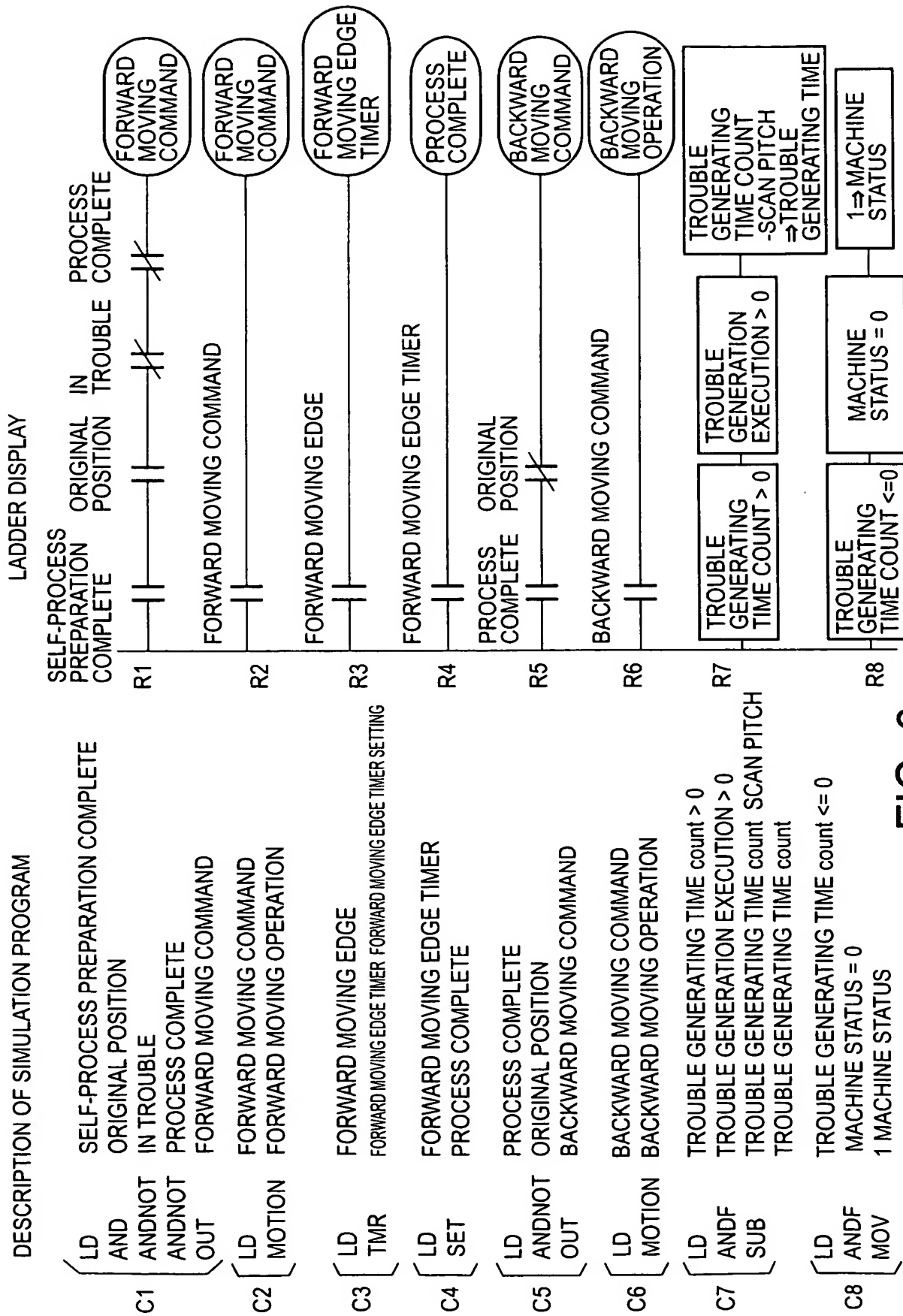


FIG. 5

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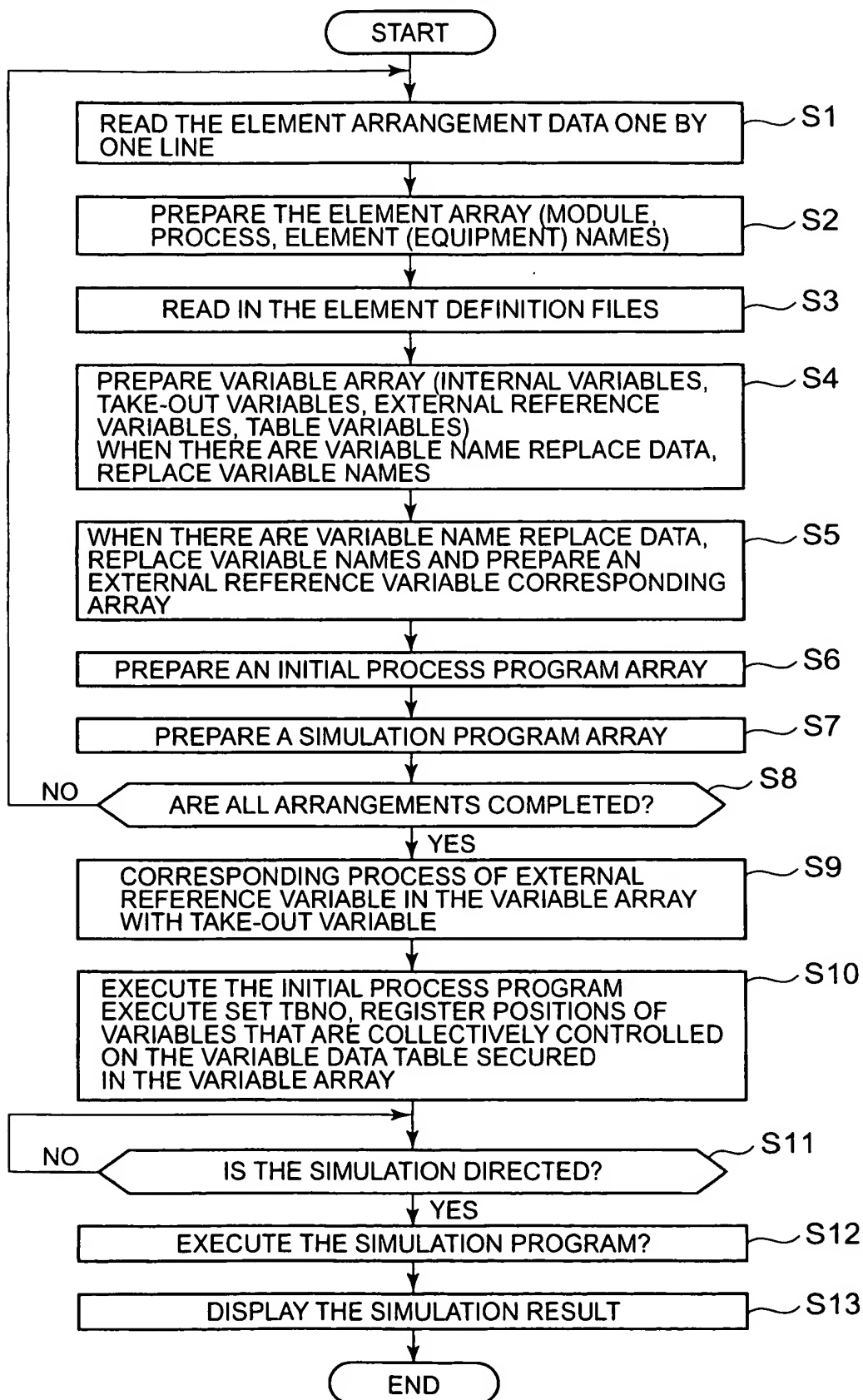


FIG. 7

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5 (ELEMENT ARRAY)

PROCESS IDENTIFICATION NAMES

POSITION IN ELEMENT ARRAY	MODULE NAME	PROCESS NAME	ELEMENT NAME	VARIABLE TOP POSITION	NUMBER
1	FRONT STOCKER		FRONT STOCKER	1	P0
2	140T	CONVEYOR	CONVEYOR	n1+1	P1
3	140T	CONNECTING TABLE	CONNECTING TABLE	n2+1	P2
4	140T	INTEGRAL	INTEGRAL 1	n3+1	...
5	140T	CONVEY	LF CONVEY
6	140T	1ST	JIG 1
7	140T	1ST	UNIT 1		
8	140T	2ST	JIG 1		
9	140T	2ST	UNIT 1		
10	140T	REAR CONNECTING TABLE	CONNECTING TABLE		
11	140T	CARRY-OUT CONVEYOR	CONVEYOR		
12	REAR STOCKER		REAR STOCKER		
13	MAINTENANCE COMMAND		MAINTENANCE COMMAND 1		
14	MAINTENANCE MEMBER A		MAINTENANCE MEMBER
15	MAINTENANCE MEMBER A		MAINTENANCE MEMBER

FIG. 8

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VARIABLE
POSITION
(ADDRESS)

ATTRIBUTE

6 (VARIABLE ARRAY)

VARIABLE NAME

VALUE/
POSITION

1	INTERNAL	d1	0mm	FRONT STOCKER
2	INTERNAL	d2	30mm	
Q1	INTERNAL	MACHINE STATUS	0	
		...		
		...		CONVEYOR (140T CONVEYOR)
n1+1		...		
R3	TAKE-OUT	a1	***	
		...		CONNECTING TABLE (140T CONNECTING TABLE)
n2+1		...		
	EXTERNAL REFERENCE	b1'	R4	
	EXTERNAL REFERENCE	a1"	R3	
		...		INTEGRAL 1 (140T INTEGRAL) UNCLAMP TABLE 20
n3+1				
L0	TAKE-OUT	UNCLAMP T[0]	2	
L0+1	TAKE-OUT	UNCLAMP T[1]	f5	
L0+2	TAKE-OUT	UNCLAMP T[2]	...	
				LF CONVEY (140T CONVEY)
n4+1		...		
R4	TAKE-OUT	b1	**	
		...		
		...		JIG (140T1ST)
n5+1	INTERNAL	...		
Q5	INTERNAL	MACHINE STATUS	0	
f5	INTERNAL	UNCLAMP	0	
...	EXTERNAL REFERENCE	INTEGRAL / UNCLAMP	L0+1	
...	EXTERNAL REFERENCE	MAINTENANCE COMMAND/MACHINE STATUS	T0+5	
...	EXTERNAL REFERENCE	UNIT PROCESS COMPLETE	R7	
R5	TAKE-OUT	PROCESS PREPARATION COMPLETE	0	UNIT (140T1ST)
		...		
n6+1	INTERNAL	FORWARD MOVING SPEED	*mm/s	
Q6	INTERNAL	MACHINE STATUS	0	
		...		
	INTERNAL	TROUBLE GENERATING TIME	1HOUR	
	INTERNAL	TROUBLE REPAIR TIME	3HOUR	
	INTERNAL	TROUBLE GENERATING TIME count	0HOUR	
	INTERNAL	TROUBLE GENERATION EXECUTION	1(YES)	
		...		
	TAKE-OUT	UNIT ORIGINAL POSITION	**	

(CONTINUED ON THE FOLLOWING PAGE)

FIG. 9

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(CONTINUED FROM THE PREVIOUS PAGE)

6 (VARIABLE ARRAY)

VARIABLE POSITION (ADDRESS)	ATTRIBUTE	VARIABLE NAME	VALUE/ POSITION
R7	TAKE-OUT	PROCESS COMPLETE	0
		...	
R6	EXTERNAL REFERENCE	SELF-PROCESS PREPARATION COMPLETE	R5
t6	EXTERNAL REFERENCE	MAINTENANCE COMMAND/MACHINE STATUS	T0+6
		...	
		...	
		...	
		...	
		...	
		...	
		...	
T0	TAKE-OUT	MACHINE STATUS	11
L0+1	TAKE-OUT	MACHINE STATUS T[1]	Q1
L0+2	TAKE-OUT	MACHINE STATUS T[2]	Q2
...	TAKE-OUT	...	
T0+11	TAKE-OUT	MACHINE STATUS T[11]	Q11
"WORKER STATUS T" TABLE			
		...	
		...	

UNIT 1 (CONTINUED)

JIG 1 (140T2ST)

UNIT 1 (140T2ST)

CONNECTING TABLE:
140T REAR CONNECTING TABLE

CONVEYOR (140T
CARRY-OUT CONVEYOR)

REAR STOCKER
(REAR STOCKER)

20

MACHINE STATUS T
TABLE

MAINTENANCE
COMMAND 1
(MAINTENANCE
COMMAND)

20

MAINTENANCE MEMBER
(MAINTENANCE MEMBER A)

MAINTENANCE MEMBER
(MAINTENANCE MEMBER B)

FIG. 10

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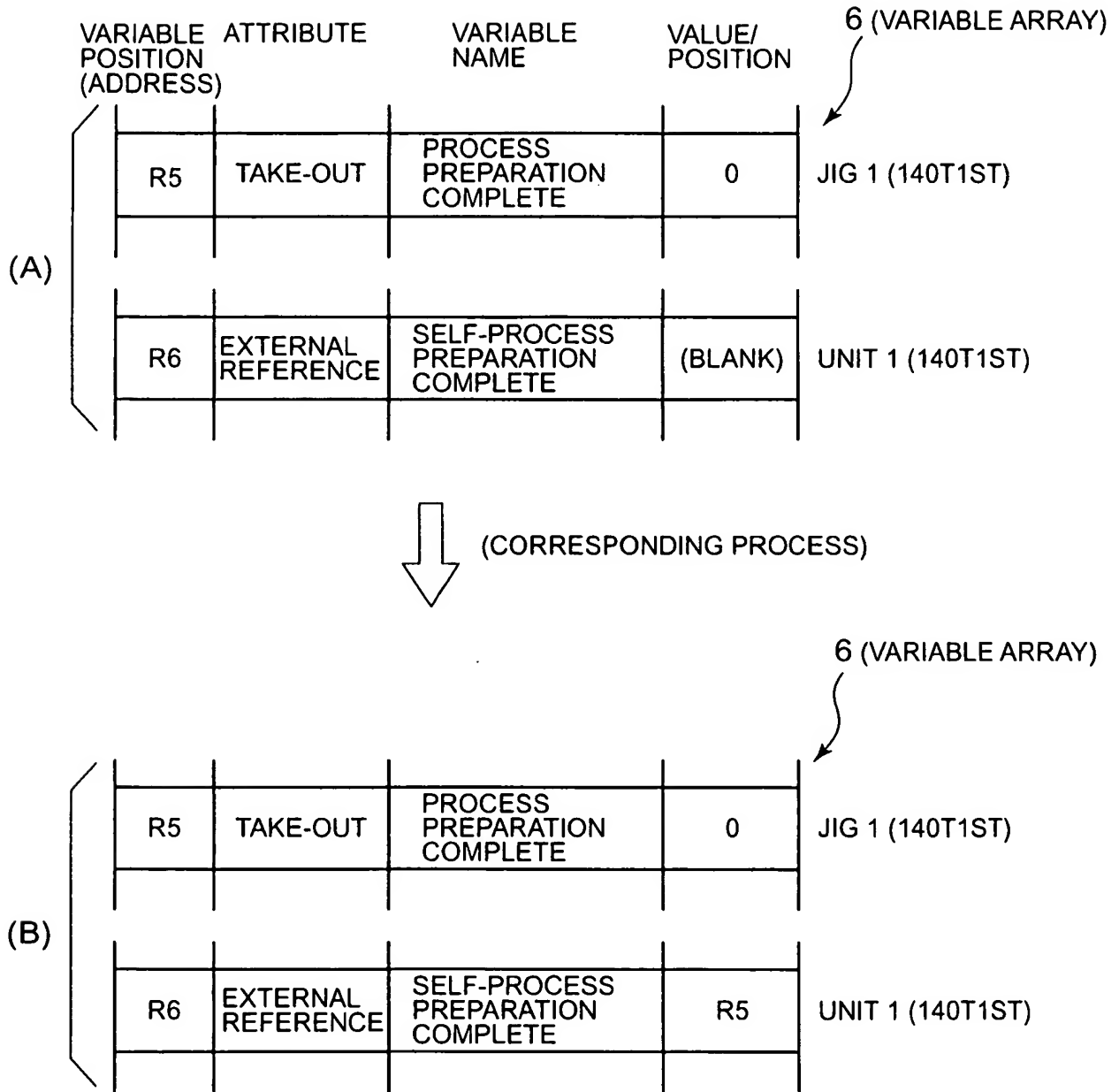


FIG. 11

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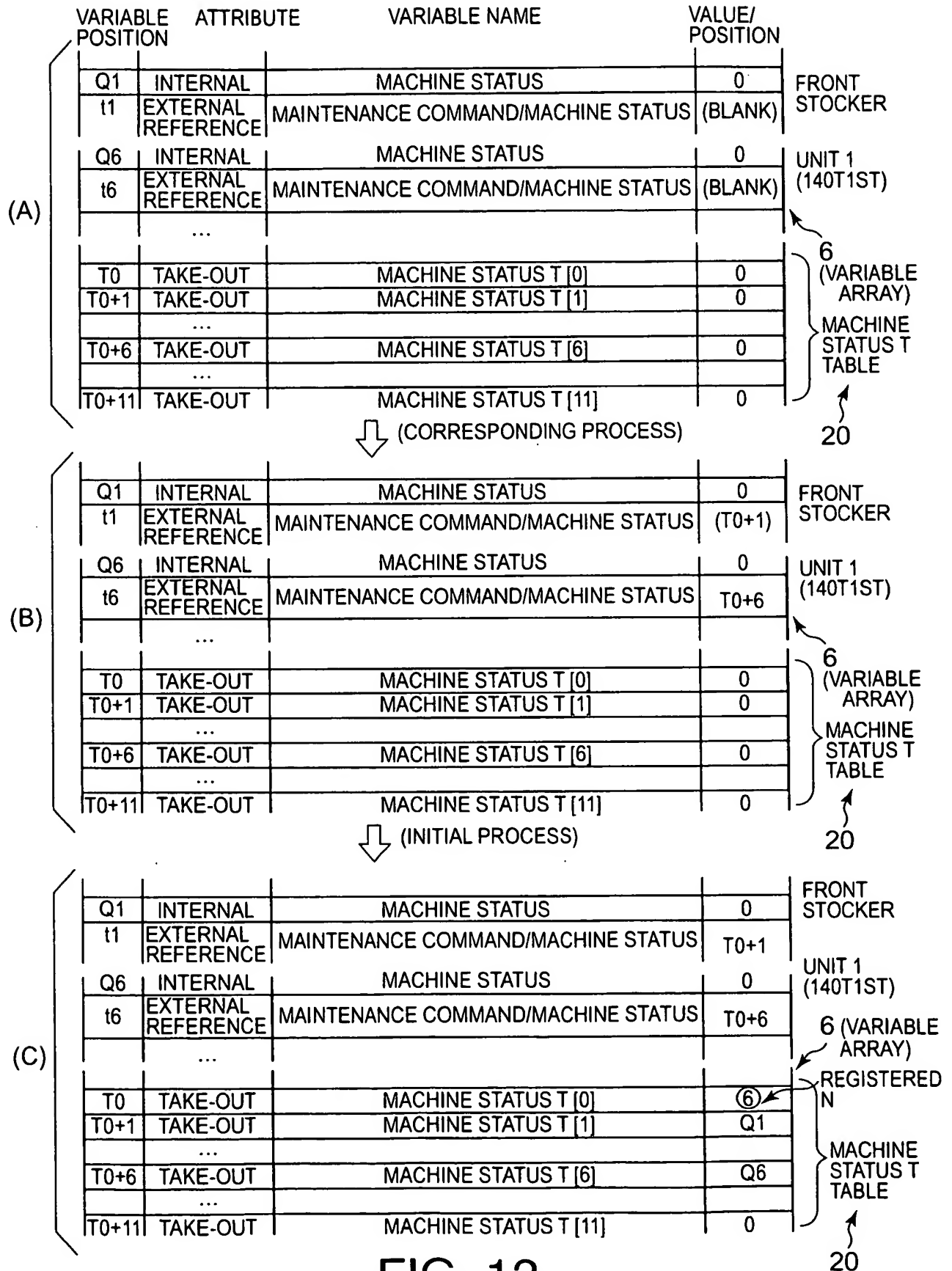


FIG. 12

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7 (EXTERNAL REFERENCE VARIABLE CORRESPONDING ARRAY)

POSITION IN ELEMENT ARRAY	EXTERNAL REFERENCE VARIABLE NAME	REFERRING VARIABLE NAME	REFERRING MODULE NAME PROCESS NAME
3	b1'	b1	140T CONVEY
3	a1"	a1	140T CONVEYOR
...			
...			
3	SELF-PROCESS PREP- ARATION COMPLETE	PROCESS PREP- ARATION COMPLETE	1401ST
...			

FIG. 13


8 (INITIAL PROCESS PROGRAM ARRAY)

FRONT STOCKER
CONVEYOR
CONNECTING TABLE
INTEGRAL 1
LF CONVEY
JIG 1
UNIT 1
JIG 1
UNIT 1
CONNECTING TABLE
CONVEYOR
REAR STOCKER
MAINTENANCE COMMAND
MAINTENANCE MEMBER
MAINTENANCE MEMBER

FIG. 14

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9 (SIMULATION PROGRAM ARRAY)



FRONT STOCKER
CONVEYOR
CONNECTING TABLE
INTEGRAL 1
LF CONVEY
JIG 1
UNIT 1
JIG 1
UNIT 1
CONNECTING TABLE
CONVEYOR
REAR STOCKER
MAINTENANCE COMMAND
MAINTENANCE MEMBER
MAINTENANCE MEMBER

FIG. 15

[illegible]

FIG. 16

